

W 5/03

DART AEROSPACE LTD	Work Order:	22077
Description: Doubler	Part Number:	D3208-9
Dwg: D3208 Rev. A1	Qty:	20 20 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10 Dwg not required	JF	04.12.08	4
2	MV	Cut blank: 4.155" x 4.560" Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3208-9	SD	04/12/08	20
3	MV	Machine D3208-9 as per Folio FA397 and Dwg D3208 Stack of 10 Identify as D3208-9	SD	05.01.19	20
4	QC2	Inspect parts as they come off the CNC machine	SD	05.01.19	20
5	QC8	Second check	EZ	05.01.19	20
6	GA	Deburr Stack	SB	05/01/24	20
7	QC5	Inspect work to Step 6	SD	05.01.24	20
8	FP	Chemical Conversion Coat as per QSI 005 4.1	SD	05-01-24	20
9	QC3	Inspect Chemical conversion Coat	MM	05.01.25	20
10	ST	Identify and Stock	JL	05-01-25	20
11	AC	Cost / part <u>8.78</u>	SAC	05-01-26	20
12	DC	Close W/O <u>8.78</u> Inspect Level 21	JF	05.01.27	20

Rev	Date	Change	Revised By	Approved
A	04.06.09	New issue	KJ/RF	KF

RELEASED

RF 04-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022077
 Project Name : D3208-9
 Project For : WK503
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3208-9
 Description : Doubler
 Manufactured : Yes
 Amount Req'd : 4
 Amount Done : 0
 Start Date : 12-06-04
 Est Finish Date : 01-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

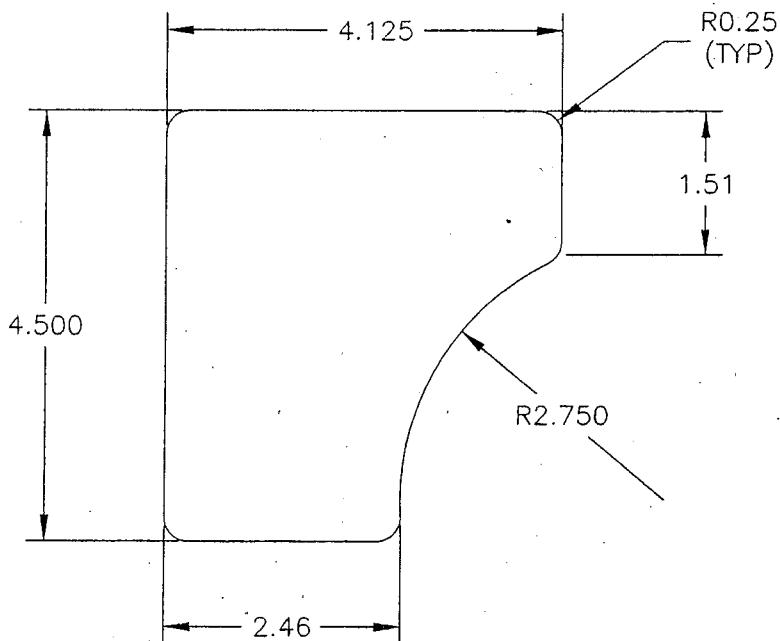
	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00

DART
CONTROLLED COPY



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TH	APPROVED TH	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED
Dartes



D3208-9 DOUBLER

SHOP COPY

RETURN TO
ENGINEERING

UNCONTR
SUBJECT
WITHOUT

WORK ORD
NO. 22071

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DART AEROSPACE LTD	Work Order:	22077
Description: Dangler	Part Number:	D 3208-9
Inspection Dwg: D 3208 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	Sb	Audited by:	EZ	Prototype Approval:	N/A
Date:	05.01.19	Date:	05.01.19	Date:	

Rev	Date	Change	Revised by	Approved
A	/	New Issue	KJ/RF	/